

Date: Friday, 9/14/2007 2:01:33 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LUG WELDMENT
Job Number : 34681	
Estimate Number : 12396	
P.O. Number : <u>N/A</u>	Part Number : D33537
This Issue : 9/14/2007 S.O. No. : <u>N/A</u>	Drawing Number : D3353 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u> Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 30458	Material : <u>N/A</u>
Written By : _____	Due Date : 9/30/2007 Qty: <u>15</u> Um: Each
Checked & Approved By : <u>0709.17</u>	
Comment : est rev. A 06.04.24 new issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M1010B0375X03500	1010-1025 Steel Bar
-----	------------------	---------------------



Comment: Qty.: 0.3360 f(s)/Unit Total : 1.3440 f(s)

1010-1025 BAR .375" thick x 3.50" batch: M102179 07-09-27

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3353

Dwg Rev: A LB 07-09-27

Prog Rev: A

2-Deburr

(15)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
-----	---------------	------------------------------



Comment: CONVENTIONAL MILLING MACHINE

1- Bore hole as per dwg D3353

2-Deburr

07-10.05 (15)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

LB 07-09-27 07-10-04

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

07-10-04 (15)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PD Date: 31/10/09
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/14/2007 2:01:33 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG WELDMENT

Job Number: 34681

Part Number: D33537

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

EP 07/10/05 (15)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



(15)

Comment: FINAL INSPECTION/W/O RELEASE

D 07/10/05

Job Completion



C207110109

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

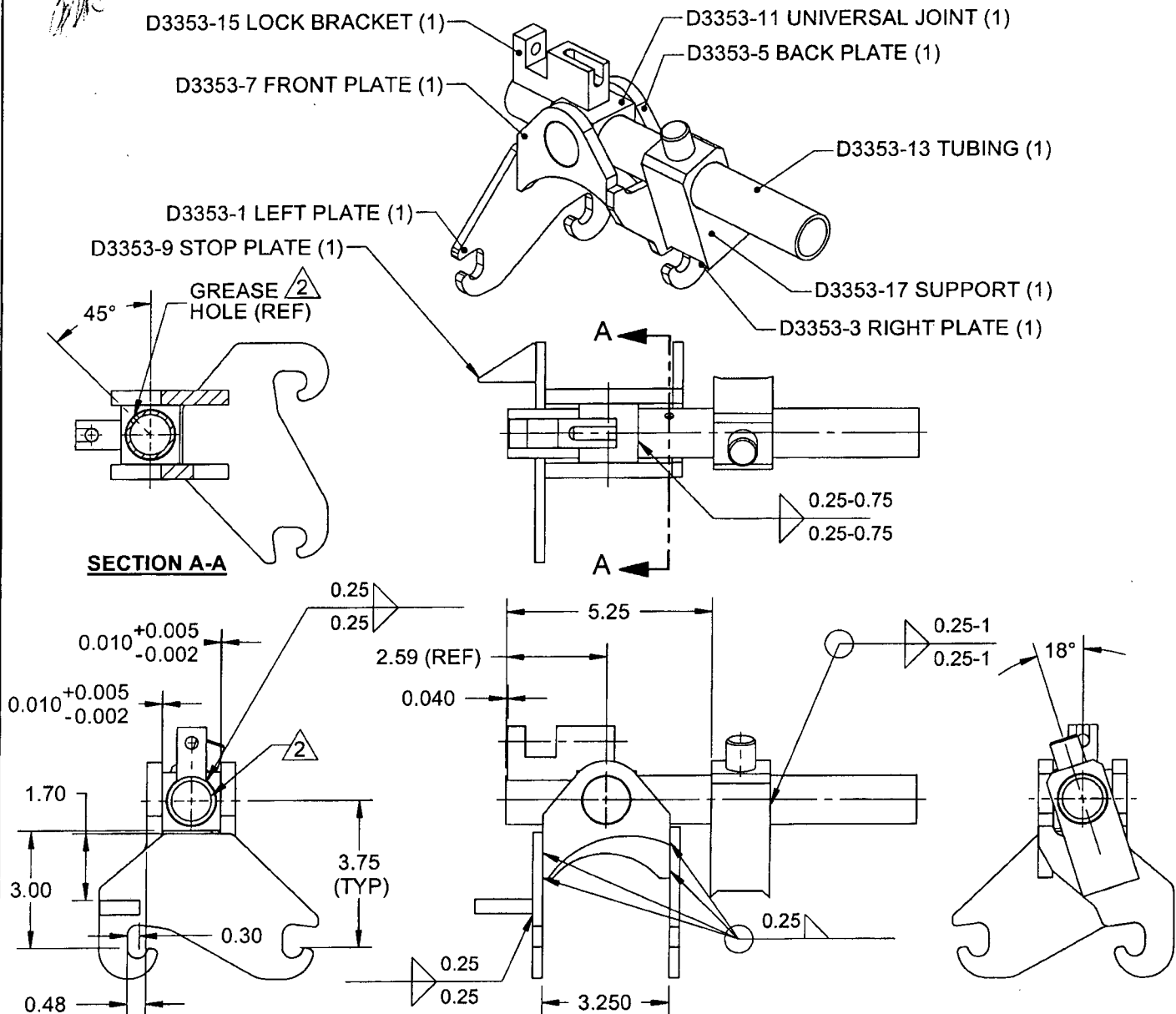
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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DATE 04.12.14	TITLE LUG WELDMENT		SCALE 1:4
A	04.12.14	NEW ISSUE	

RELEASED
[Handwritten: 06/30/14]**D3353-041 LUG WELDMENT****NOTES:**

- 1) WELD PER DART QSI 004
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005-4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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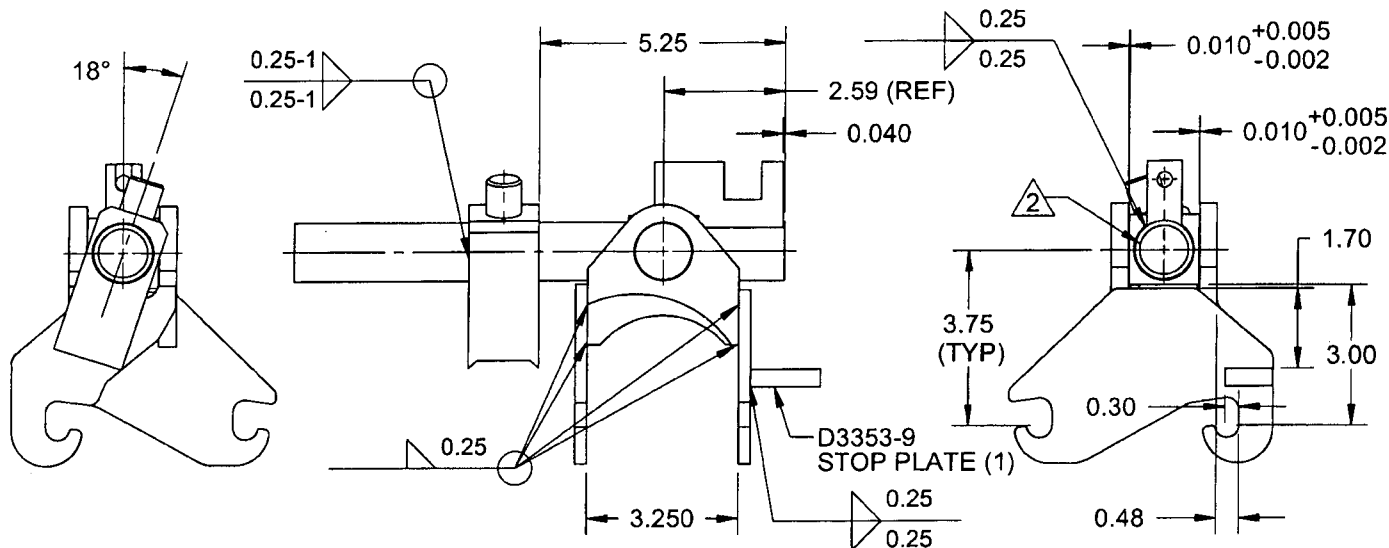
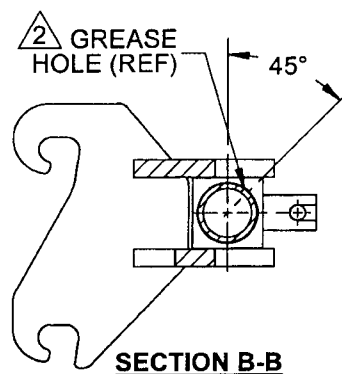
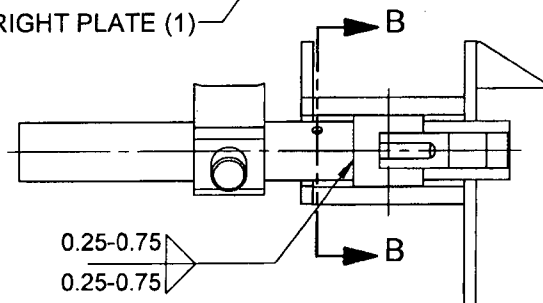
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DATE 04.12.14	TITLE LUG WELDMENT		SCALE 1:4

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06/03/59

D3353-11 UNIVERSAL JOINT (1)
D3357-5 BACK PLATE (1)
D3353-17 SUPPORT (1)
D3353-13 TUBING (1)
D3353-3 RIGHT PLATE (1)
D3353-15 LOCK BRACKET (1)
D3353-7 FRONT PLATE (1)
D3353-1 LEFT PLATE (1)

**D3353-042 LUG WELDMENT****NOTES:**

- 1) WELD PER DART QSI 004
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005.4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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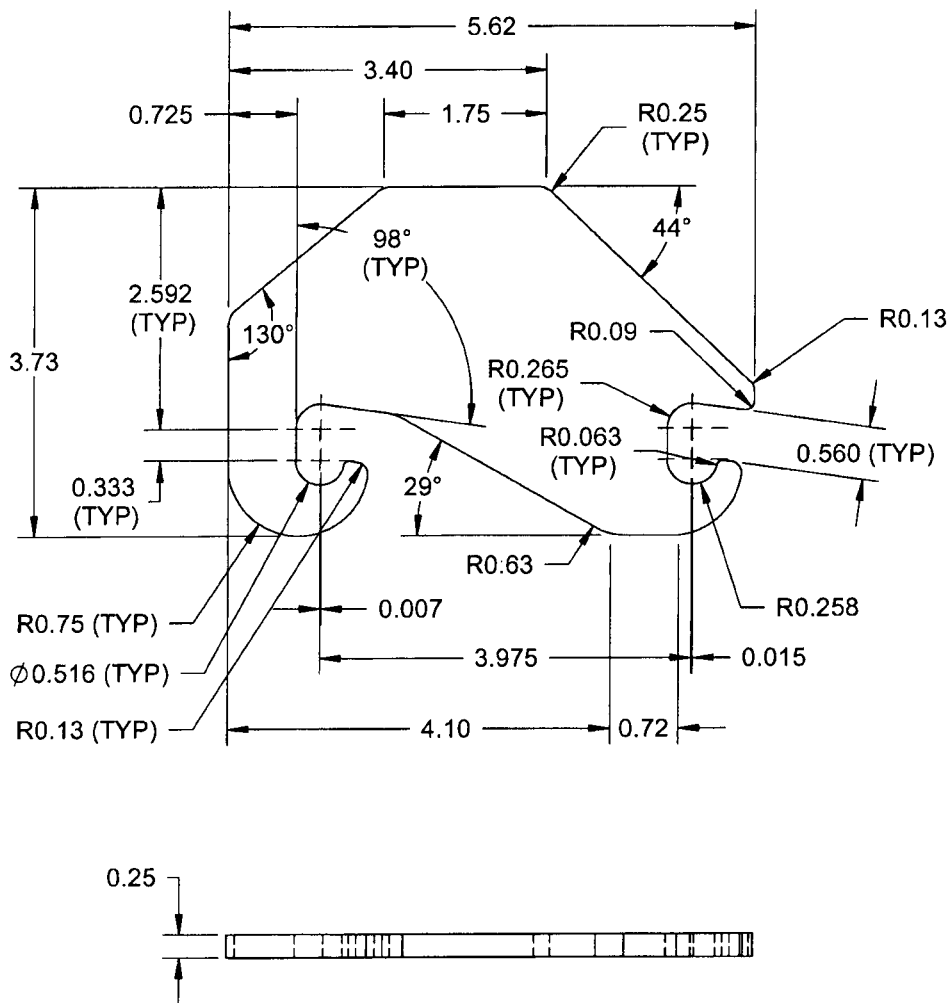
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01/07/14



D3353-1 LEFT PLATE

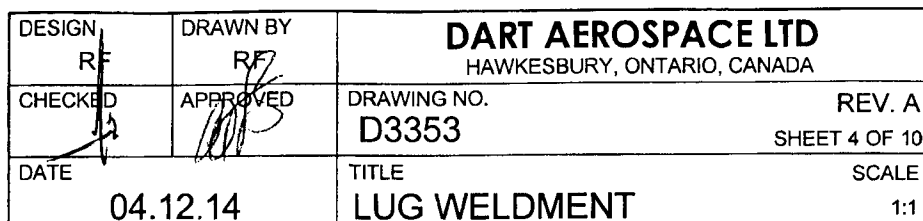
NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 3 GAUGE (0.250 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

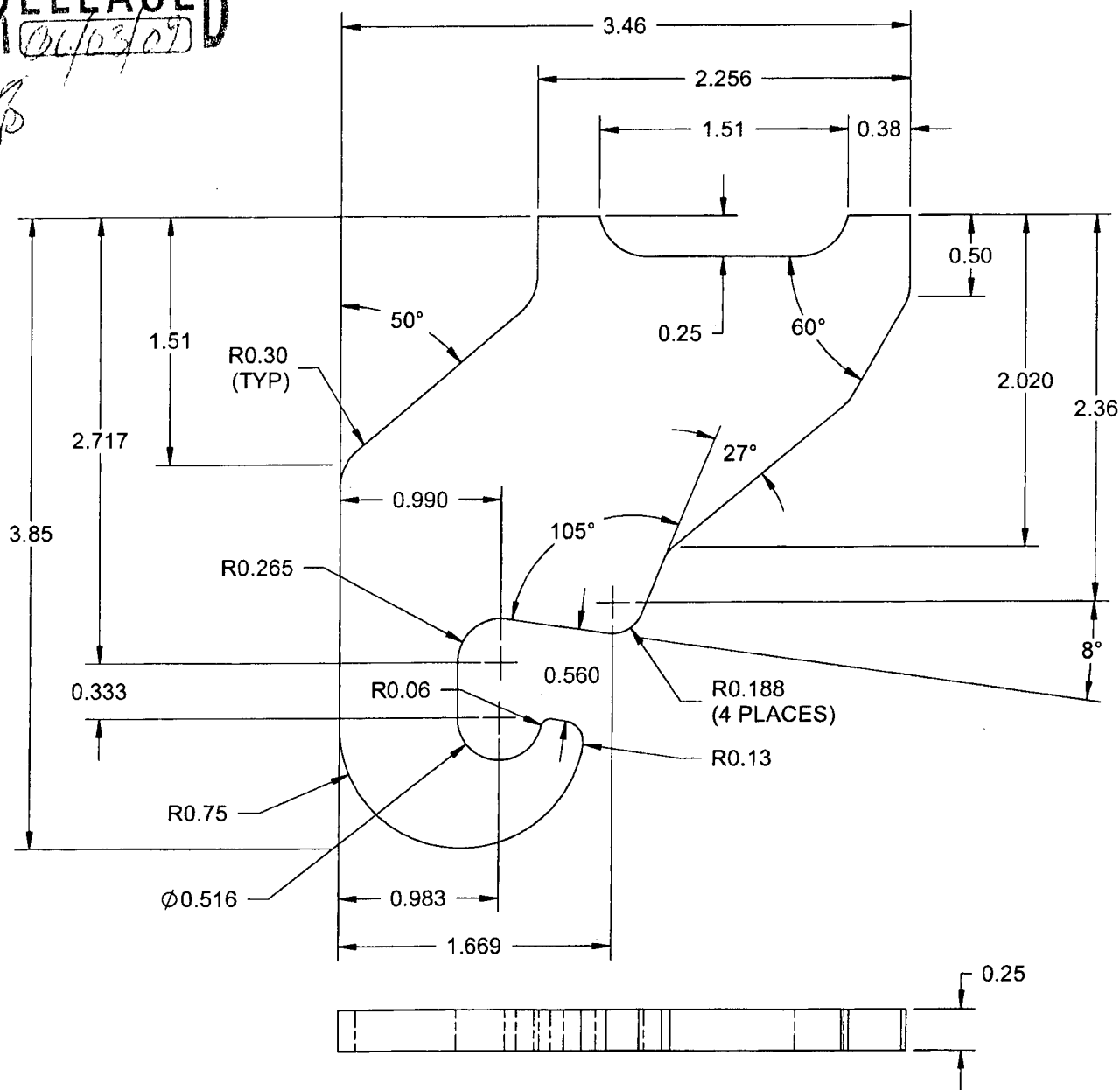
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D3353-3 RIGHT PLATE

1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A108 OR CSA G40.21,
38W/44W/50W/60W/70W SERIES STEEL 3 GAUGE (0.250 THICK)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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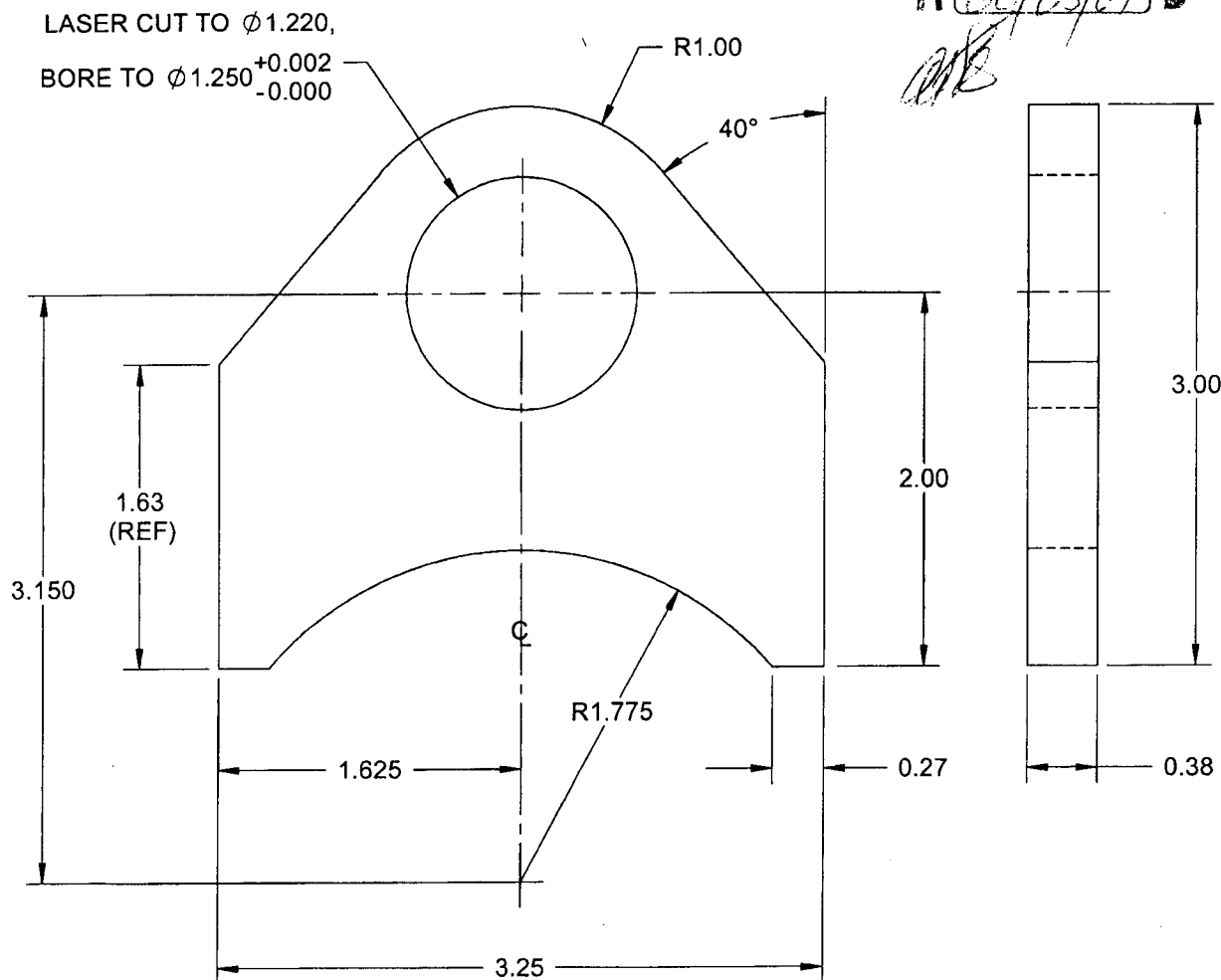
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DATE 04.12.14	TITLE LUG WELDMENT		SCALE 1:1

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[Stamp: 06/03/09]



D3353-5 BACK PLATE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A108 OR CSA G40.21, 38W/44W/50W/60W/70W SERIES STEEL 0.375 THICK PLATE
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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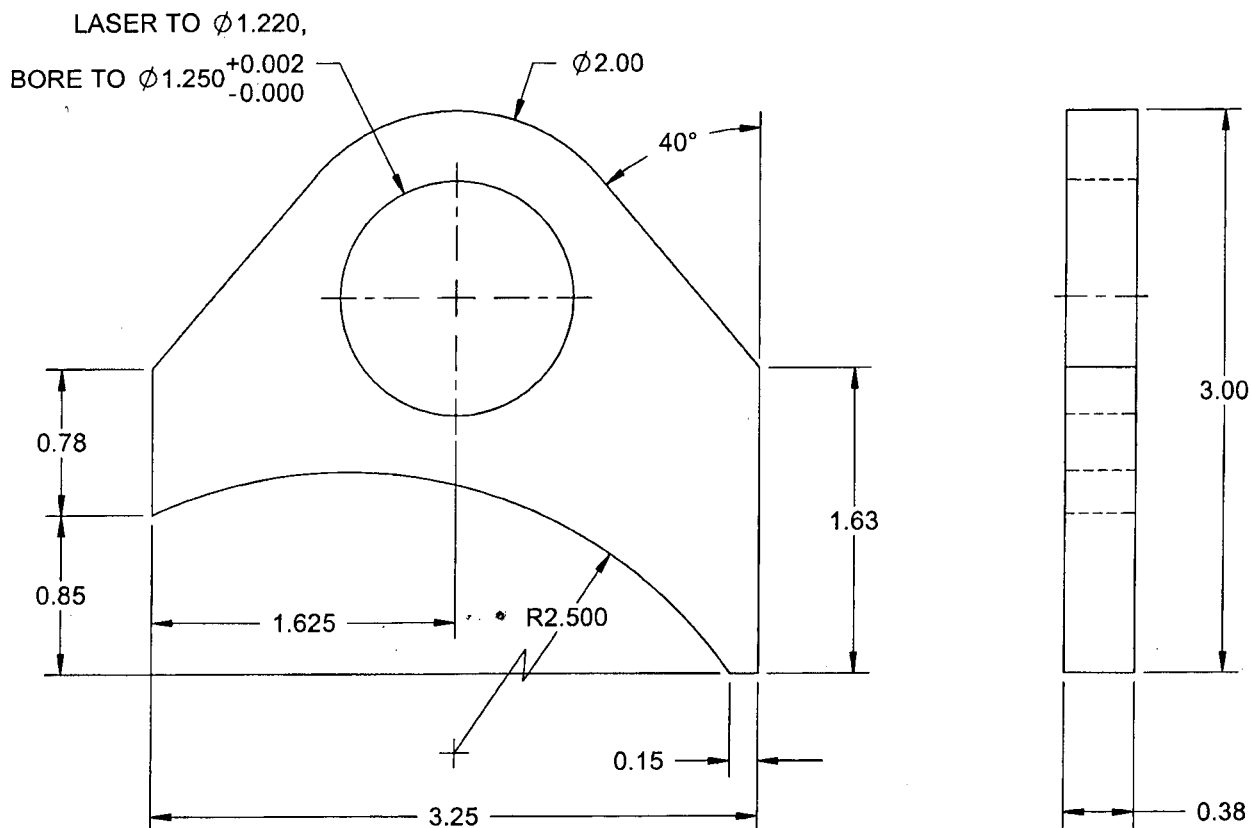
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D3353-7 FRONT PLATE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A108 OR CSA G40.21, 38W/44W/50W/60W/70W SERIES
STEEL 0.375 THICK PLATE
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi

- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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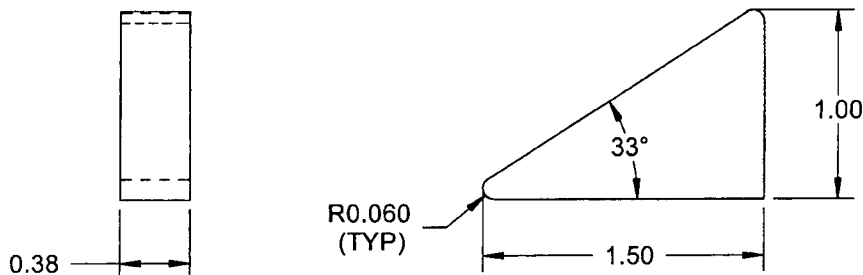
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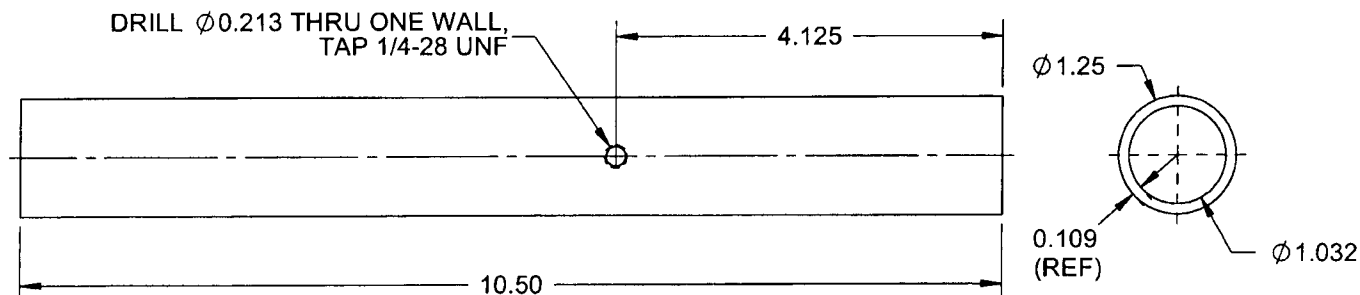
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02/33/04

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D3353-9 STOP PLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR
CSA G40.21, 38W/44W/50W/60W/70W, 0.375 THICK
MILD STEEL BAR (REF. DART SPEC. M1010-B)



D3353-13 TUBING

NOTES:

- 1) MATERIAL: MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077,
Ø1.250 x 0.125 WALL, COLD DRAWN STEEL TUBING
(REF. DART SPEC. M1020TR1.250W.109)

NOTES:

- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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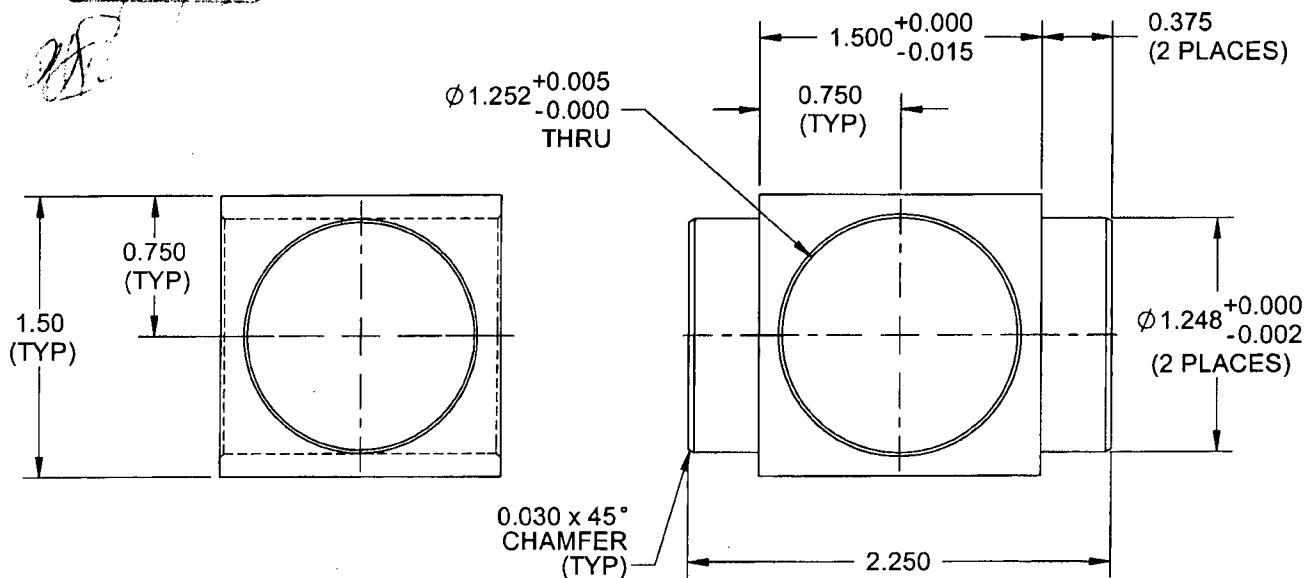
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DATE 04.12.14	TITLE LUG WELDMENT		SCALE 1:1

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04/33/07



D3353-11 UNIVERSAL JOINT

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 1.50 SQUARE MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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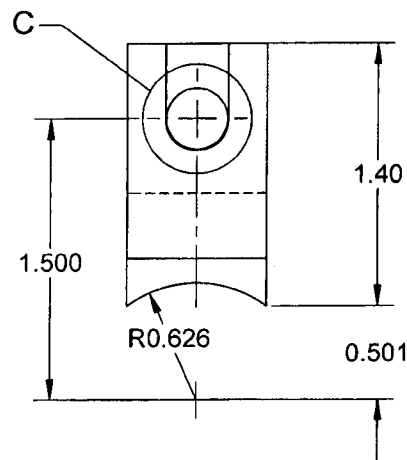
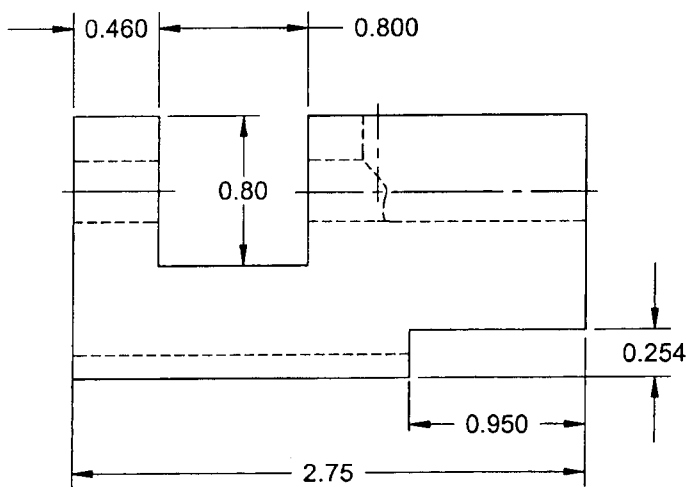
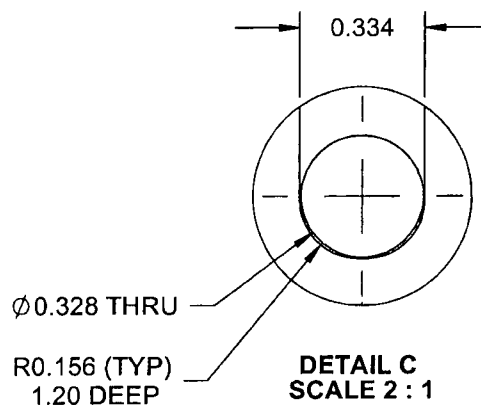
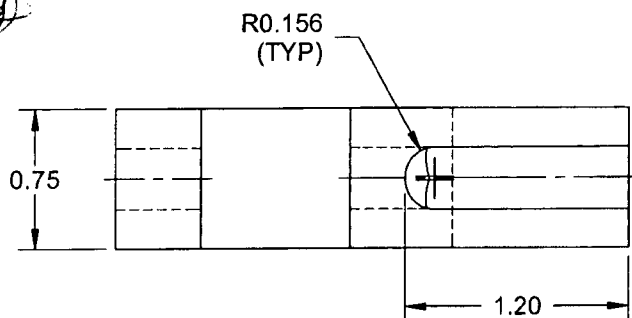
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DATE 04.12.14	TITLE LUG WELDMENT		SCALE 1:1

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86/02/09

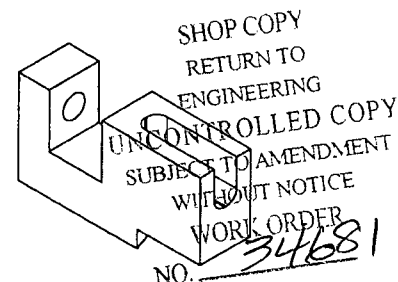
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D3353-15 LOCK BRACKET

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 0.75 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020



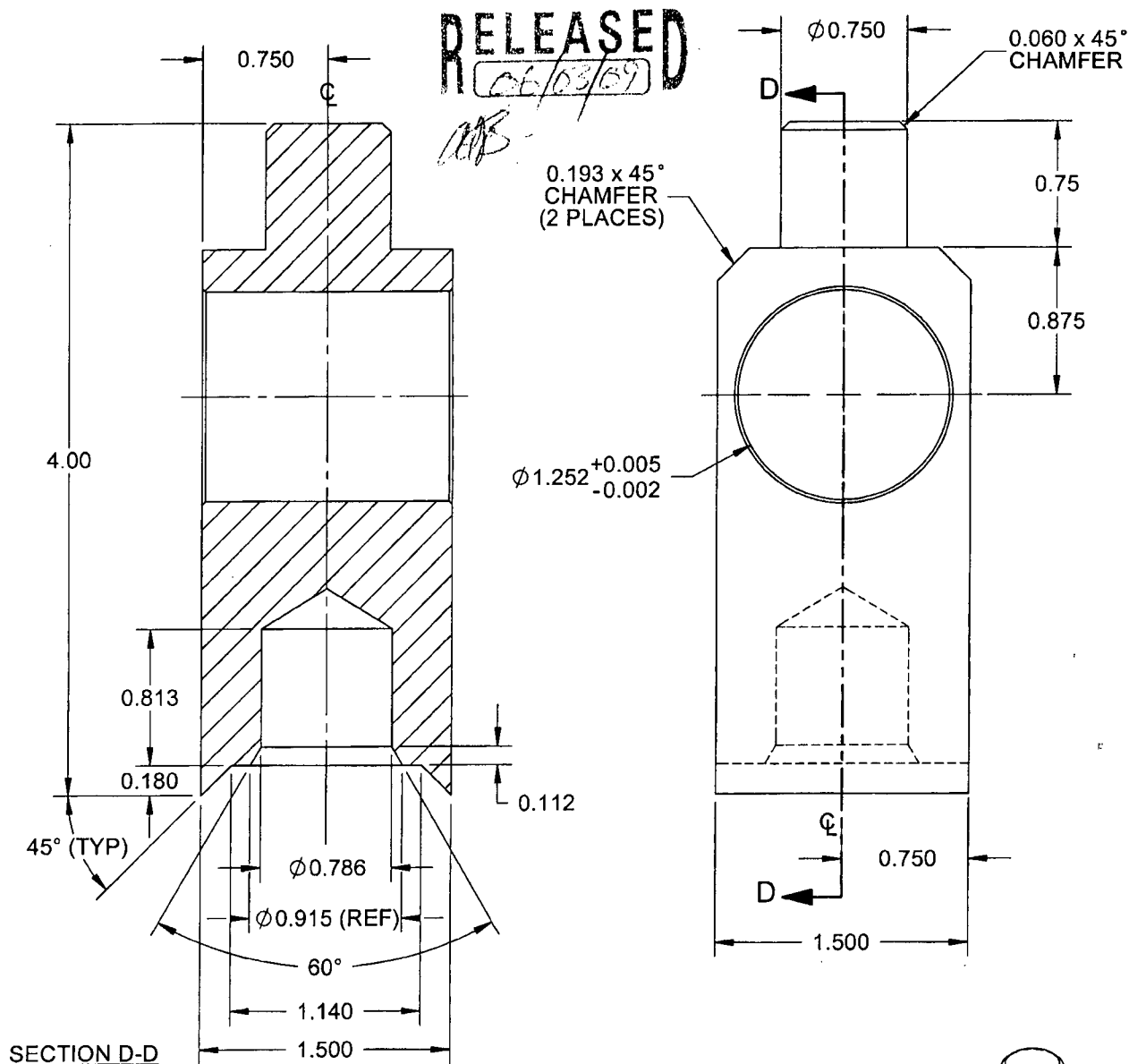
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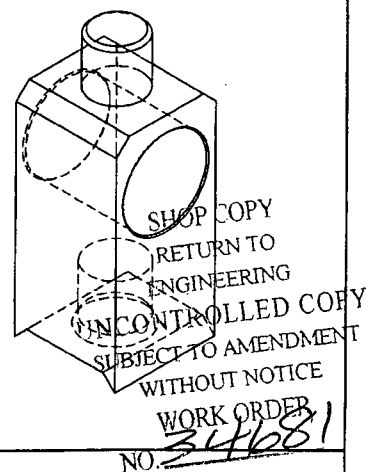
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DATE 04.12.14	TITLE LUG WELDMENT		SCALE 1:1

**D3353-17 SUPPORT****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 1.50 SQUARE MILD STEEL BAR (REF. DART SPEC. M1010-B1.500x01.500)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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